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D130-1048-011
Job Sheet 184671



Part No: D130-1048-011

Job Qty: 1 ea

Part Name: EC130 Skidtube Installation, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 10/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D130-1048-011 REV.A IPP REV:A DP verify DD 17.07.09

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/31/18	0.00	0.00	Start Up Handfinish		
110	HandFinish	1 pcs		10/31/18	0.00	0.50	HandFinish4		
120	QC	1 pcs		10/31/18	0.00	0.00	QC5		
130	Packaging	1 pcs		10/31/18	0.00	0.00	Packaging1-6		
135	QC	1 pcs		10/31/18	0.00	0.00	QC4		
140	Packaging	1 pcs		10/31/18	0.00	0.00	Packaging3-2		
155	DC	1 pcs		10/31/18	0.00	0.00	DC		
165	QC21-SA	1 Ea		10/31/18	0.00	0.00	QC21		

Part Op 110 - ASSEMBLE AS PER DWG

Descriptions: 130 - BAG AND ID HARDWARE.

140 - Identify and pack for shipping as per PPP D130-1048-011 Location: _____ PPP Rev: _____

155 - Photocopy blue file and create labels as per PPP D130-1048-011 chg 001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
22201BC120090L	Bolt	1 Ea (1 ea)	90-Start up Operation	5107718
23111AG120LE	Washer	1 Ea (1 ea)	90-Start up Operation	5096097
AN3C5A	Bolt	8 Ea (8 ea)	90-Start up Operation	5095211
AN8C56A	Bolt	3 Ea (3 ea)	90-Start up Operation	5109122
ASN52320BH120N	Nut	1 Ea (1 ea)	90-Start up Operation	FM1135885
D130-1048-041	EC130 Skidtube Assembly, LH	1 Ea (1 ea)	90-Start up Operation	5123007
D5465-1	FWD LH OEM Replacement Wearplate	1 Ea (1 ea)	90-Start up Operation	5119040
D5478-1	AFT OEM Replacement Wearplate	1 Ea (1 ea)	90-Start up Operation	5189031
D5569-1	Skidtube Blade	1 Ea (1 ea)	90-Start up Operation	5116175
D5570-1	Blade Plug	1 Ea (1 ea)	90-Start up Operation	5102643
D5594-1	GH Bushing	6 Ea (6 ea)	90-Start up Operation	5119445
D5594-3	GH Washer	6 Ea (6 ea)	90-Start up Operation	5101022
NAS1149C0332R	Washer	8 Ea (8 ea)	90-Start up Operation	1808467
NAS1149C0832R	Washer	3 Ea (3 ea)	90-Start up Operation	50760172
NAS1291C8	Nut, Self-Locking	3 Ea (3 ea)	90-Start up Operation	5112909
23111AG100LE	Washer	1 Ea (1 ea)	130-Packaging	
ASNA0045BC100L	Nut, Castellated	1 Ea (1 ea)	130-Packaging	
DHS411-101.3106	Metric Hex Head Aerospace Bolt	1 Ea (1 ea)	130-Packaging	
EN2367-48028	Cotter Pin	1 Ea (1 ea)	130-Packaging	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	22201BC120090L	1	6	0
	23111AG120LE	1	0	0
	AN3C5A	8	1,715	0
	AN8C56A	3	30	0
	ASN52320BH120N	1	15	0
	D130-1048-041	1	0	0
	D5465-1	1	2	0
	D5478-1	1	2	0
	D5569-1	1	8	0
	D5570-1	1	8	0
	D5594-1	6	0	0
	D5594-3	6	0	0
	NAS1149C0332R	8	3,734	0
	NAS1149C0832R	3	396	0
	NAS1291C8	3	38	0
130-Packaging	23111AG100LE	1	9	0
	ASNA0045BC100L	1	9	0
	DHS411-101.3106	1	7	0
	EN2367-18028	1	0	0
	MS21141S-06-05	20	100	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



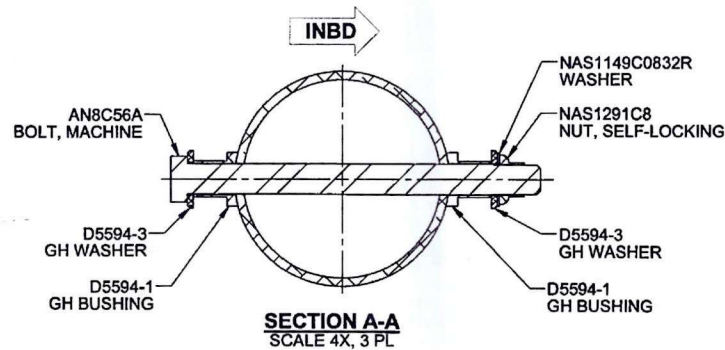
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

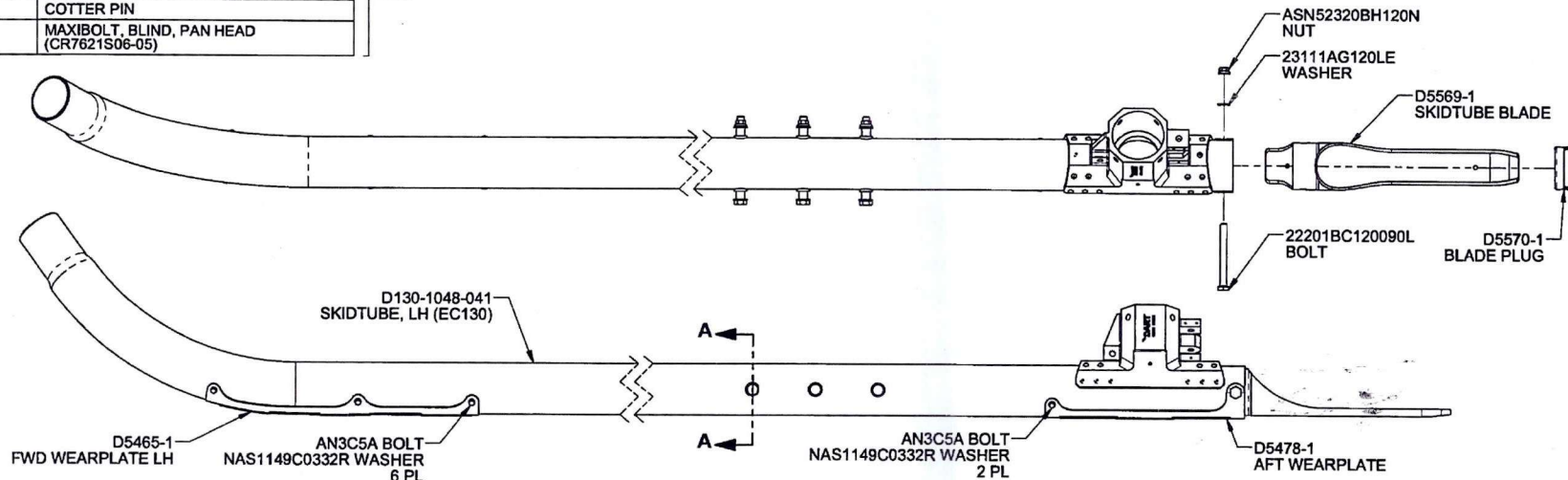
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER :			

QTY -011	P/N	DESCRIPTION
X	D130-1048-011	SKIDTUBE INSTALLATION, LH (EC130)
1	D130-1048-041	SKIDTUBE ASSY, LH (EC130)
1	D5465-1	FWD WEARPLATE LH
1	D5478-1	AFT WEARPLATE
1	D5569-1	SKIDTUBE BLADE
1	D5570-1	BLADE PLUG
6	D5594-1	GH BUSHING
6	D5594-3	GH WASHER
1	22201BC120090L	BOLT
1	23111AG120LE	WASHER
8	AN3C5A	BOLT
3	AN8C56A	BOLT, MACHINE
1	ASN52320BH120N	NUT
8	NAS1149C0332R	WASHER
3	NAS1149C0832R	WASHER
3	NAS1291C8	NUT, SELF-LOCKING
1	23111AG100LE	WASHER
1	ASNA0045BC100L	NUT, CATELLATED
1	DHS411-101.3106	BOLT
1	EN2367-18028	COTTER PIN
20	MS21141S0605	MAXIBOLT, BLIND, PAN HEAD (CR7621S06-05)



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 15467145
1870-16



D130-1048-011 SKIDTUBE INSTALLATION, LH (EC130)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: N/A
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 25.41 lbs
 - 8) HARDWARE NOT SHOWN. TO BE SHIPPED LOOSE.

RELEASED

2018 OCT 02
EN 18-017

APPROVED

REV.	DESCRIPTION	ZF	DATE
A	NEW ISSUE		18.05.08
DESIGN	NO		
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	JFS		
APPROVED	NO		
DE APPR.	CP		
DATE	18.05.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D130-1048-011

REV. A
SHEET 1 OF 1

TITLE
SKIDTUBE INSTL, LH (EC130)

SCALE
NTS

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>184671</u> Part No. <u>D130-D48-011</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) INSP 12 <i>[Signature]</i> 10/10/25	
Description Work Order Deviation		Disposition		Completed By	
EN 2367-18028 not available 23111 AG 120LE not available		use MS24665-231 instead use LN9025-1220L instead		<i>[Signature]</i> 10/10/25	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only ☐

Job: <u>184671</u> Part No. <u>D130-1048FA11/-012</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		INSP 12 <u>UP 11/1/16</u> Completed By <u>UP 11/1/16</u> Lead hand / Supervisor QC / QA Coordinator	
Blade too loose Blade bolt too short		Install blade with Sikaflex use NAS 1149C0832R instead of LN 9025-1220L			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			